

Date: Wednesday, 07/01/2009 12:42:56 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 44449
 Estimate Number : 10858
 P.O. Number :
 This Issue : 07/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D34075
 Drawing Number : D3407 REV E
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : E
 Material :
 Previous Run : 44200 Due Date : 12/01/2009 Qty: 30 Um: Each
 Written By :
 Checked & Approved By : JLD 09-01-09
 Comment : Est Rev:A New Issue 05-11-22 JLM
 Est Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
 Est Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B0250X4000 17-4 SS Bar .250 X 4.00



Comment: Qty.: 0.2799 Ft(s)/Unit Total : 8.3979 Ft(s)
 Material: 17-4ph SS 4.00" X .250" THK
 Identify for D3407-5
 Batch: 110291 IB 9-1-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3407
 Dwg Rev: E
 Prog Rev: E

IB 9-1-22

2-Break edges on grinder as per Dwg D3407

IB 9-1-22 DEBURR M/L 09/01/26 (31)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-1-22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 02/01/26 (31) water

Date: Wednesday, 07/01/2009 12:42:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 44449

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eric L.

SS 09/01/26 (x31)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09-01-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

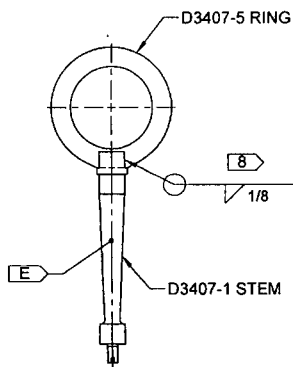
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

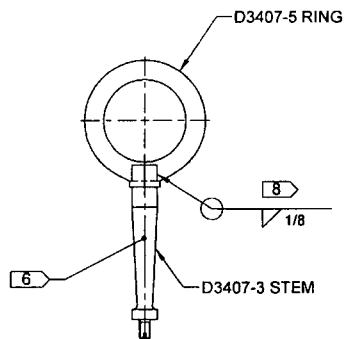
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

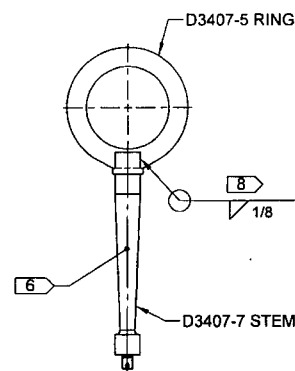
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



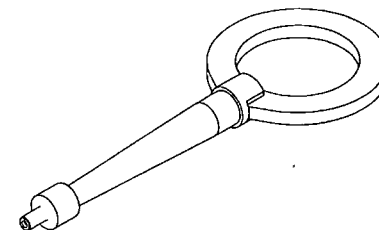
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



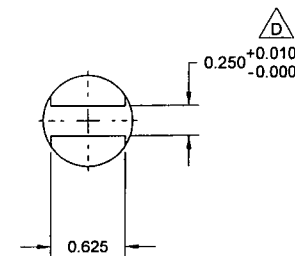
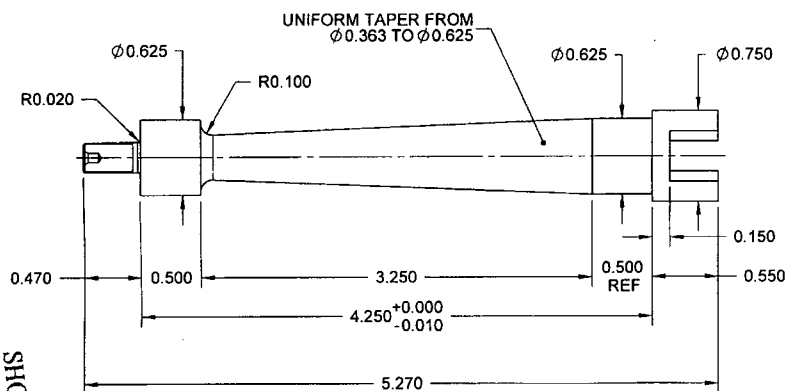
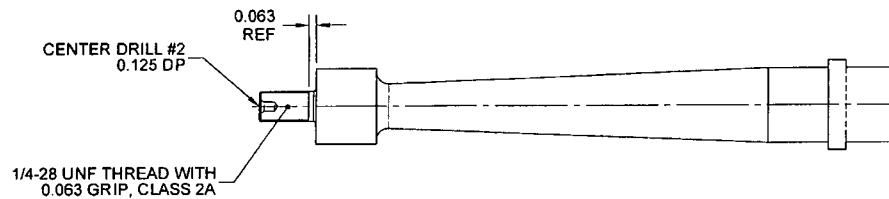
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07-08-21-1115

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WITHOUT NOTICE
NO 211115

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. E
MFG. APPR.	PA	D3407	SHEET 1 OF 5
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	TOW RING	NTS
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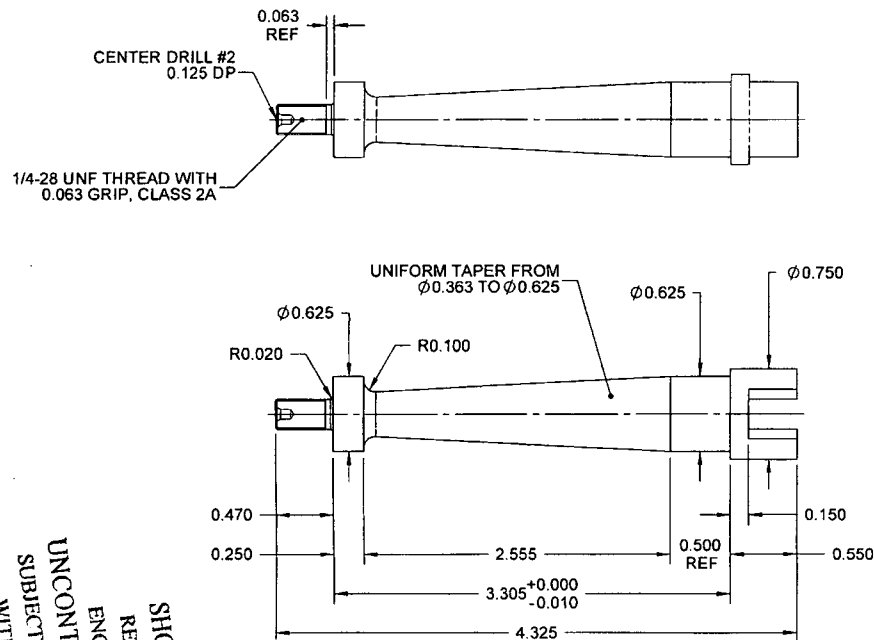
D3407-1 STEM

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08-07-23

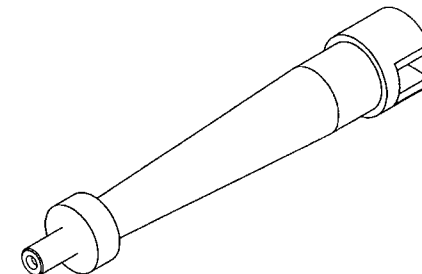
NO. 14448
WORK ORDER
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- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO. D3407	REV. E
MFG. APPR.		SHEET 2 OF 5	
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D3407-3 STEM

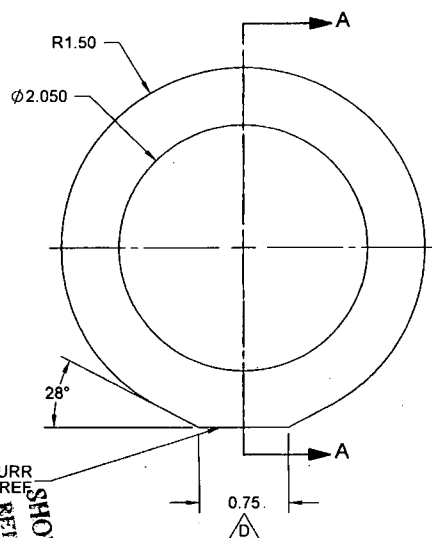


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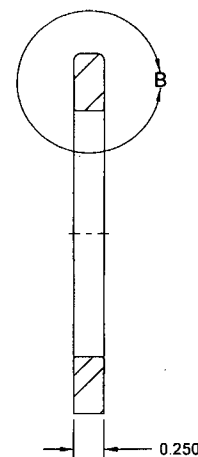
- NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

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08-08-01-149

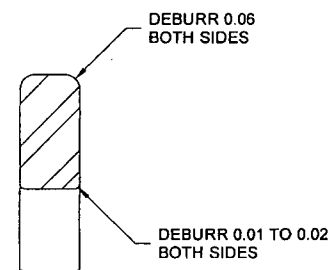
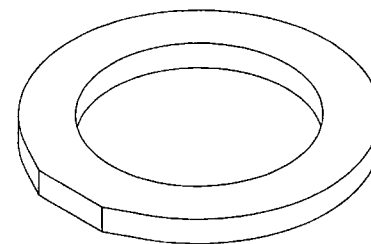
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DRAWN	HP	PORT HADLOCK, WA	
CHECKED	HP	DRAWING NO.	REV. E
MFG. APPR.	HP	D3407	SHEET 3 OF 5
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D3407-5 RING



SECTION A-A



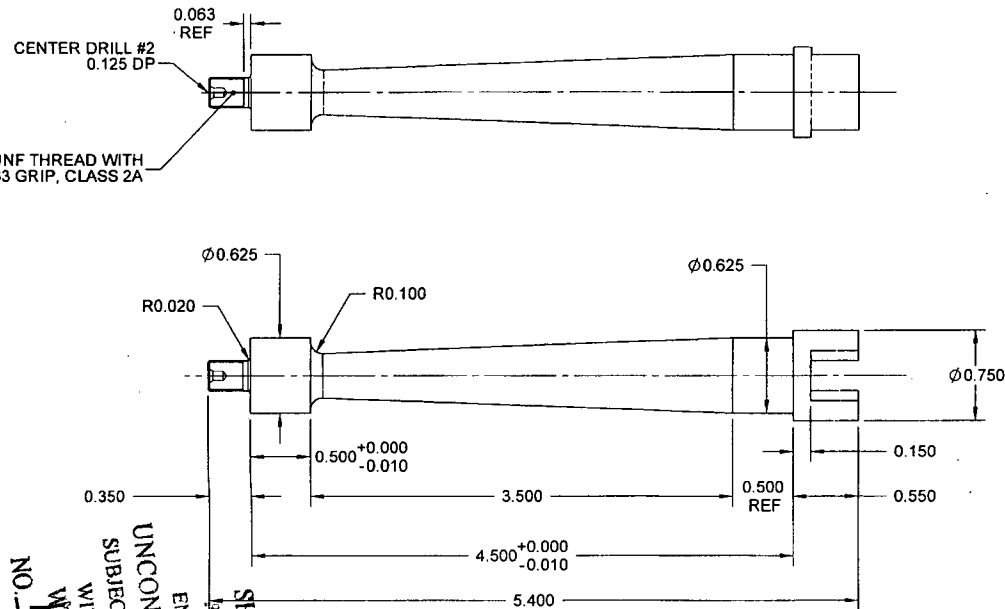
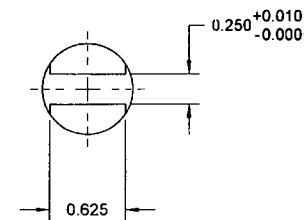
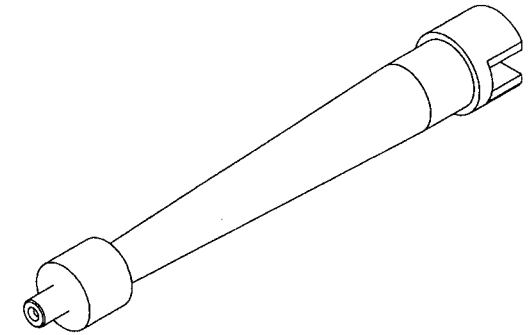
**DETAIL B
SCALE 2X**

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- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs






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D3407-7 STEM

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08-09-01 MP

NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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